

Work Order ID 50147

July 8, 2009 1:16:01 PM



Page 1

Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 7/14/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/31/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D2512	Rev E

100



Large Fab

0.00

Large Fab

Memo

0.00

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512 2-Cut (4) D2236 From D3166-3 Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305



5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

Work Order ID 50147

July 8, 2009 1:16:01 PM



Page 2

Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 7/14/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/31/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC6- Inspect dimensions to drawing

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

PRESSURE WASHER

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

0.00

COAT:1 START TIME: 8:45 COAT:2 START TIME: 10:00

COAT:1 FINISH TIME: 9:15 COAT:2 FINISH TIME: 10:35

COAT:1 OVEN TEM: 400 COAT:2 OVEN TEM: 400

0.00

0.00

140



HandFinish

Hand Finishing

HandFinishing

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4
Batch: M111013 M111283

M 09-07-27 X

Work Order ID 50147

July 8, 2009 1:16:01 PM



Page 3

Item ID: D2512

Revision ID: E

Item Name: Basket Lid 205/350

Start Date: 7/14/09 Start Qty: 1.00

Accept



Setup Start



Required Date: 7/31/09 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

160



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

0.00

→ Start

AP 50085

9/12/09 ROSC

8/28/09

09/07/29 HJ

Picklist Print

Page 1

July 8, 2009 1:16:00 PM

Work Order ID: 50147



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 7/14/09

Required Date: 7/31/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-1RevC 		Manufactured	No			100	Each	12.0000	2.0000			

Basket Hinge

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

12

48230

2 ✓

D2327-1RevD



Manufactured

No

100

Each

20.0000 2.0000



Spacer Bushing

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

20

46325

2 ✓

D2506RevF



Manufactured

No

100

Each

5.0000 1.0000



Label Plate

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

5

44275

48607

4

B 50027 → 2 ✓

Picklist Print

July 8, 2009 1:16:01 PM

Page 2

Work Order ID: 50147



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 7/14/09

Required Date: 7/31/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No			100	Each	35.0000	2.0000			

Mounting Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

35

{46086
48428}

2

33

2 (P) 09-07-21 ✓

D3166-3RevA1



Manufactured

No

Basket Hoop

M304EX0.75-16F



Purchased

No

Expanded Metal Flat SS

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

818.0437

108152

90

110134

6.7

110292

14.4

110629

14.41

110861

21.18

110992

0.58

111444

17.79

111630

35.15

111956

36.36

112147

581.4737

2.0

16.0

3AD 09-07-22

(Qty)
1

Picklist Print

July 8, 2009 1:16:01 PM

Page 3

Work Order ID: 50147



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 7/14/09

Required Date: 7/31/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

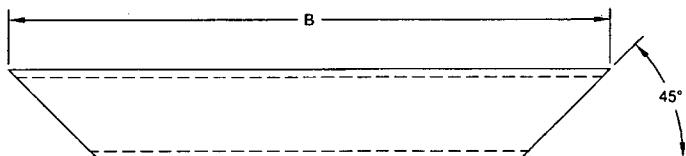
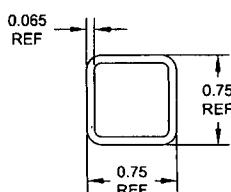
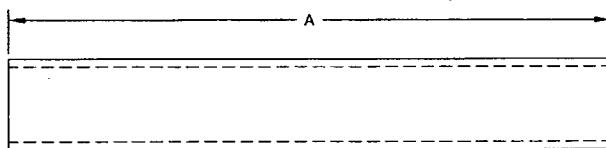
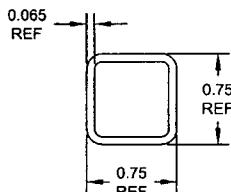
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased		No		100	f	463.0861	45.8741			

304 SQ Tube .75x.75x.065W

	<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	Main Warehouse		
	MAT	463.0861	
	110969	3.29	
	111148	15.96	
	111331	1.96	
	111432	0.44	
	111885	25.14	
	112051	416.2961	
			45.8741 5A0 09-07-22 (Qty 1)

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



E

D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

W
S0147

RELEASED
08-08-21-118

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3. ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		REV. E	
MFG. APPR.		DRAWING NO.	
APPROVED		D2512	SHEET 1 OF 4
DE APPR.		TITLE	SCALE
		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE THAN THE PERSON TO WHOM IT IS GIVEN HAS BEEN GRANTED WRITTEN PERMISSION FROM DART AEROSPACE LTD	

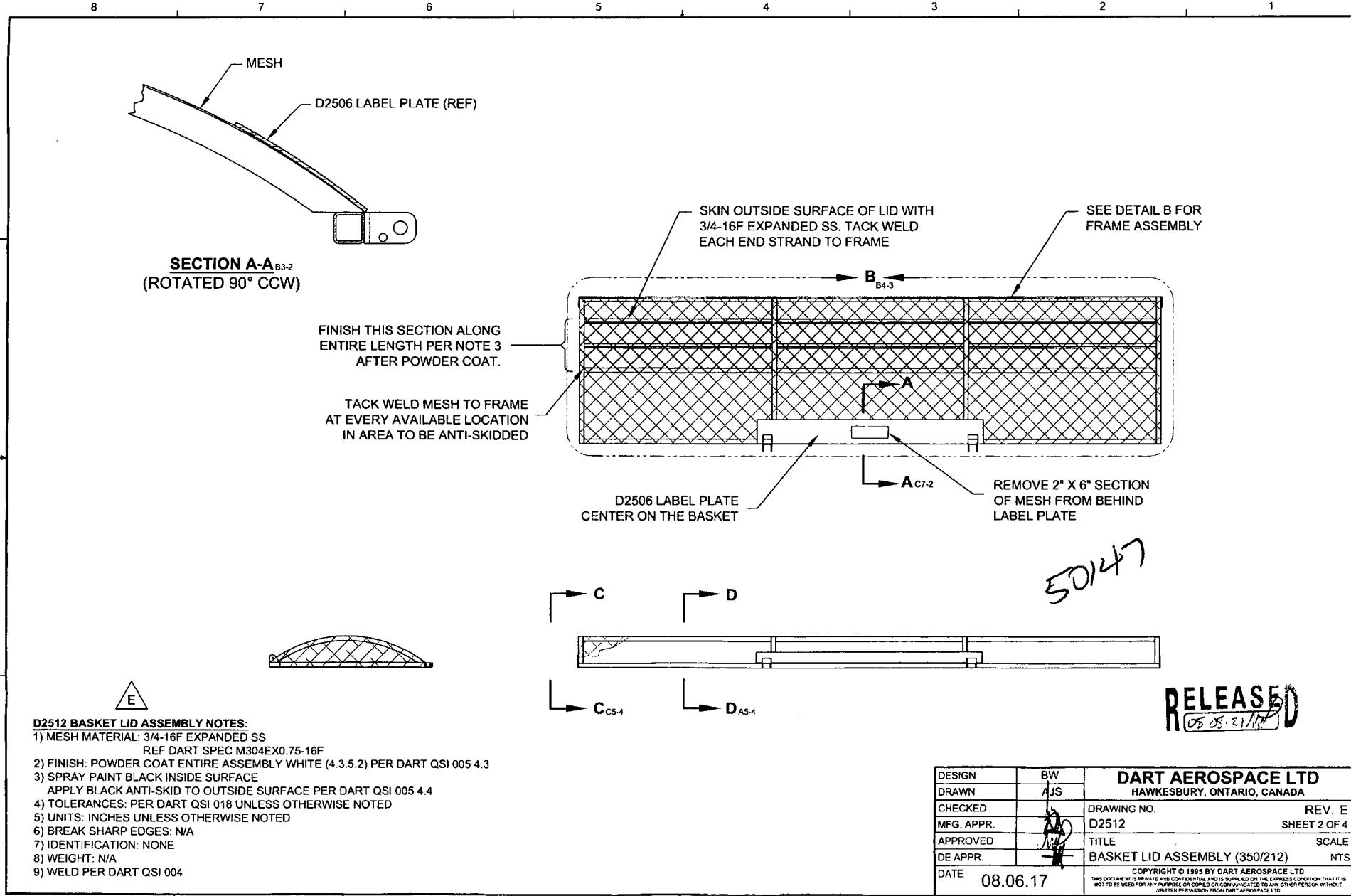
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



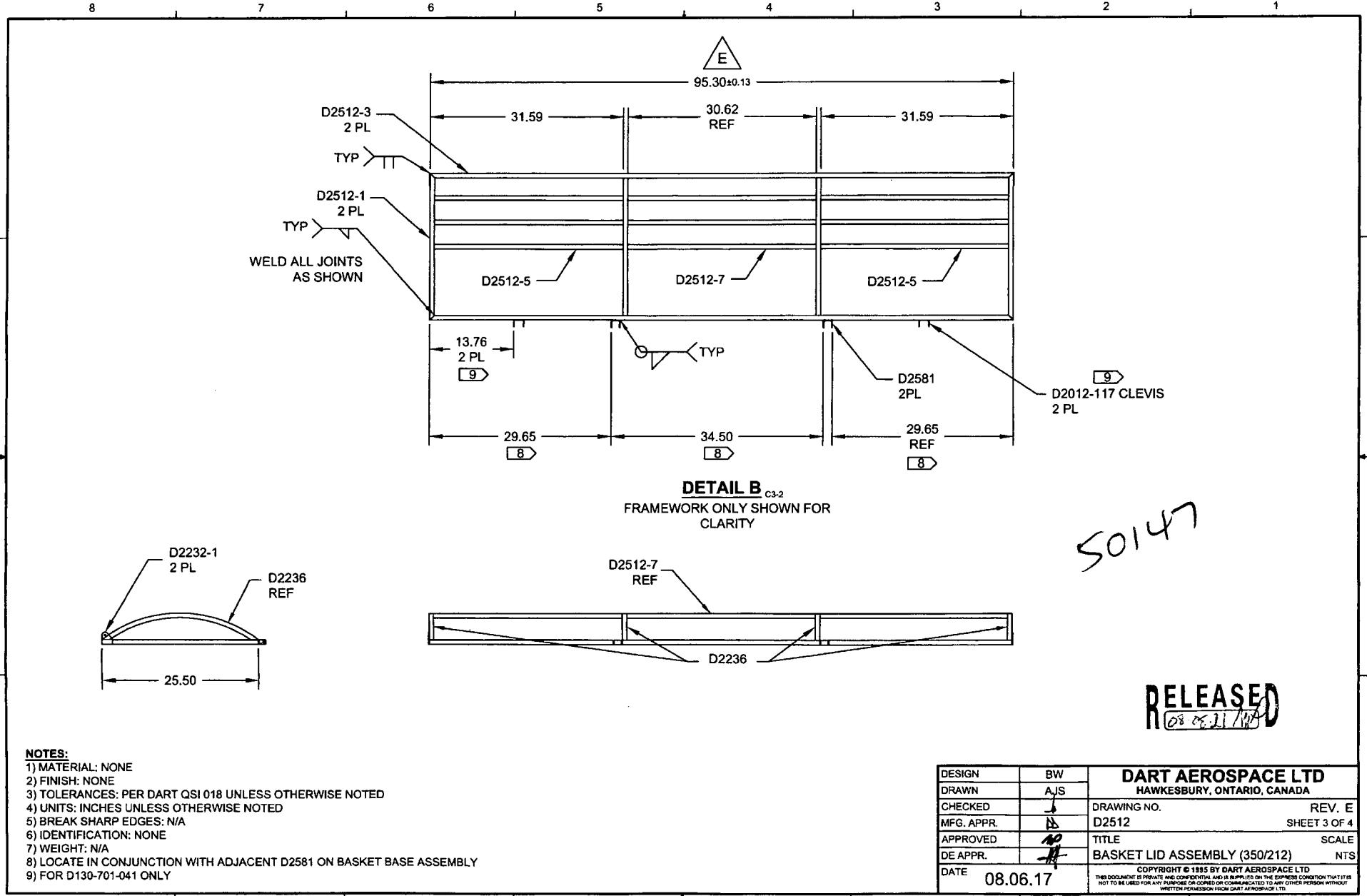
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

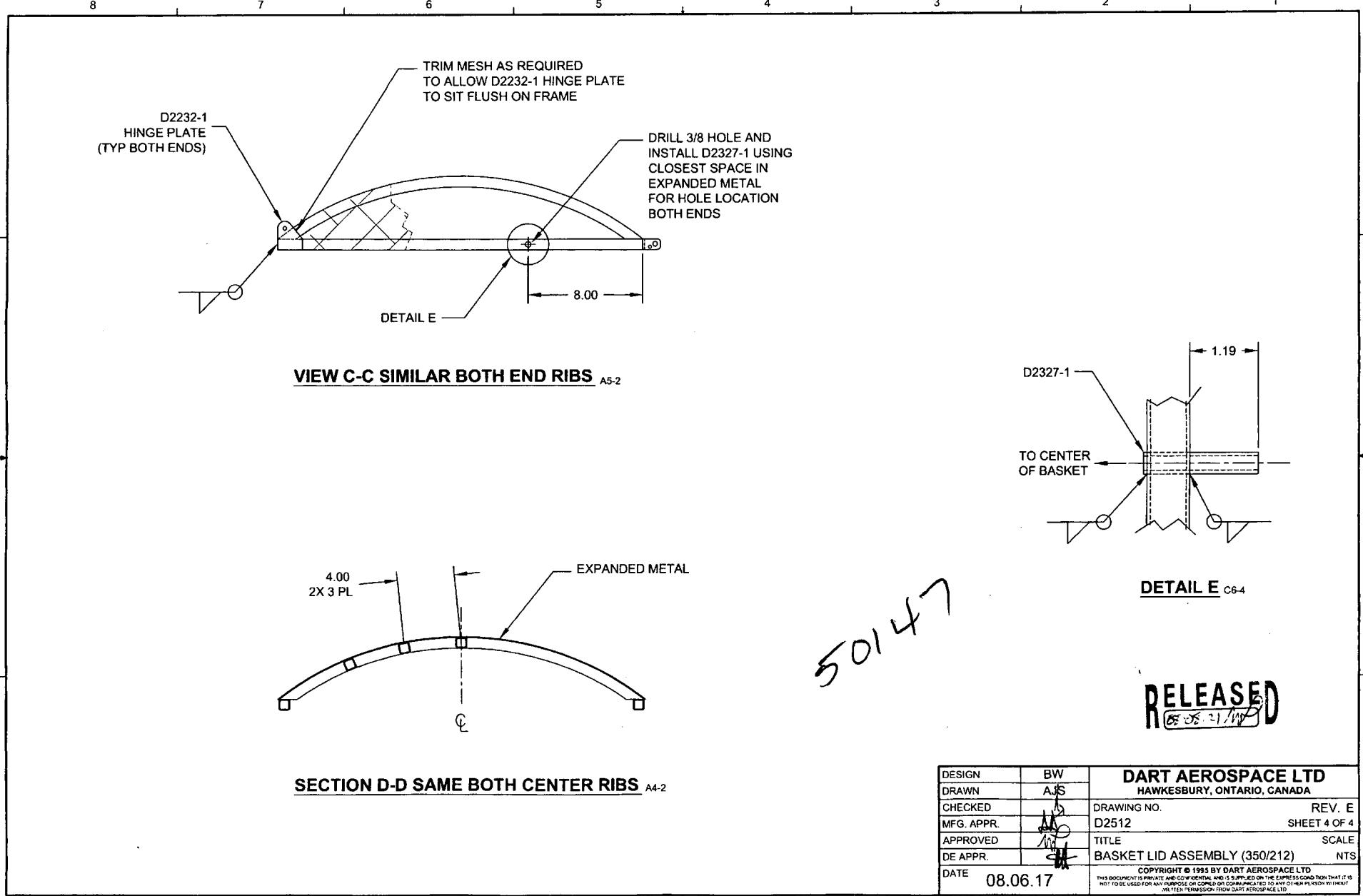


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries